

Date: Monday, 07/04/2008 11:46:52 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: PASSENGER DOOR WINDOW KIT
<b>Job Number</b>	: 38419		
<b>Estimate Number</b>	: 10922		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D044713015
<b>This Issue</b>	: 07/04/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: N/A
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 33911	<b>Drawing Revision</b>	: N/A
	<b>Type</b> : SMALL /MED FAB	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 14/04/2008
<b>Checked &amp; Approved By</b>	: <u>JO 08.4.06</u>	<b>Qty:</b>	3 Um: Each
<b>Comment</b>	: Est Rev:A 05.03.22 New issue KJ/JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefiles &amp; DT8721 Cutting Template and create labels per PPP D044-713-015CHG001

08/04/08 JLD

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D2126	Seal
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**Comment:** Qty.: 6.0000 f(s)/Unit Total: 18.0000 f(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2126-72.0"

Seal

35251

AS 08/04/08 (X3)

4.0	D2977	Hinge Bracket
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2977

Bracket

B19560

AS 08/04/08 (X3)

5.0	D32791	Passenger Window, R44
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

30203

AS 08/04/08 (X3)

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PASSENGER DOOR WINDOW KIT

Job Number: 38419

Part Number: D044713015

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D3279-1

Window

6.0

MS2104208

USE MS21042L08



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 MS21042-08

Nut

M100903

1 DT8721

Cutting Template

No Bar nodes  
for L08.

JS 08/04/08 (x3)

7.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

JS 08/04/09 (x3)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D044-713-015

Location:

PPP Rev:

Craft

8/4/9

SEA 3x

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/14

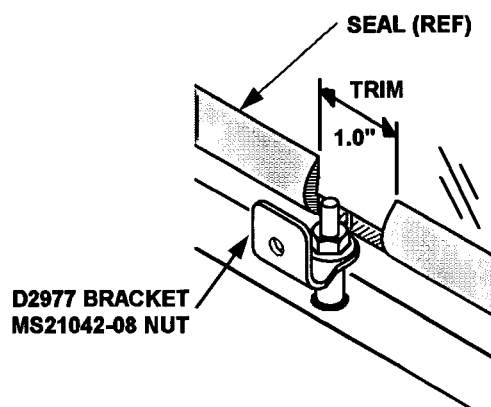
Job Completion



MF

08-04-10

u



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38419

FIGURE 52-3 – D044-713-015 Passenger Door Window Kit – Lock/Seal Detail

## 52.7 WEIGHT AND BALANCE

The following are the net weight increase associated with the modification kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
<b>D044-713-011</b> Crew Door Window Kit	1.5 lb 0.68 kg	±24 in ±0.61 m	±36 in-lb ±0.43 m-kg	66 in 1.68 m	99 in-lb 1.1 m-kg
<b>D044-713-013</b> Bubble Window Kit, LH	2.5 lb 1.1 kg	-28 in -0.71 m	-70 in-lb -0.78 m-kg	66 in 1.68 m	165 in-lb 1.8 m-kg
<b>D044-713-014</b> Bubble Window Kit, RH	2.5 lb 1.1 kg	+28 in +0.71 m	+70 in-lb +0.78 m-kg	66 in 1.68 m	165 in-lb 1.8 m-kg
<b>D044-713-015</b> Passenger Door Window Kit	1.2 lb 0.54 kg	±23 in ±0.58 m	±28 in-lb ±0.31 m-kg	83 in 2.11 m	100 in-lb 1.1 m-kg

## 52.8 PARTS LIST

Qty -011	Qty -013	Qty -014	Qty -015	Part Number	Description
X				D044-713-011	CREW DOOR WINDOW KIT, (FITS LH & RH)
	X			D044-713-013	BUBBLE WINDOW KIT, LH
		X		D044-713-014	BUBBLE WINDOW KIT, RH
			X	D044-713-015	PASSENGER DOOR WINDOW KIT, (FITS LH & RH)
			1	D2126-0720	SEAL
1	1	1		D2126-0903	SEAL
	1			D3269-1	BUBBLE WINDOW, LH
		1		D3269-2	BUBBLE WINDOW, RH
1				D3277-1	WINDOW
			1	D3279-1	WINDOW
	1	1		D3312-1	PLACARD
			1	D2977	BRACKET
			1	MS21042-08	NUT
*1	*1	*1		DT8720	D044-713-011/-013/-014 CUTTING TEMPLATE (FWD DOOR)
			*1	DT8721	D044-713-015 CUTTING TEMPLATE (AFT DOOR)

\* Not to be installed. Cutting template only.

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